



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3077-1
Job Sheet 178498



Part No: D3077-1

Job Qty: 10 ea

Part Name: Step Leg



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev: B 02.11.18 Incorporated D3170-1 IPP KJ IPP Rev: C 06-04-27 Manufactured on Water Jet JLM IPP Rev: D 06-06-23 Now 6061-T6 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	6/15/18	6/15/18	0.00	0.00	Start Up Waterjet		SS 18/06/14
100	Waterjet	10 pcs	6/15/18	6/15/18	0.00	1.29	Waterjet1		SS 18/06/14
110	QC	10 pcs	6/15/18	6/15/18	0.00	0.00	QC2 Waterjet-1		SS 18/06/14
120	QC	10 pcs	6/15/18	6/15/18	0.00	0.00	QC8-1		38
130	Small Fab	10 pcs	6/15/18	6/15/18	0.00	0.00	Small Fab 2 D/A		9-89
140	HandFinish	10 pcs	6/15/18	6/15/18	0.00	0.42	HandFinish1		SA 18-06-21
150	QC	10 pcs	6/15/18	6/15/18	0.00	0.00	QC7-2		38
160	QC	10 pcs	6/15/18	6/15/18	0.00	0.00	QC5		9-89
170	Packaging	10 pcs	6/15/18	6/15/18	0.00	0.00	Packaging3-1		D. M. / 18-6-25
180	QC21-SA	10 Ea	6/15/18	6/15/18	0.00	0.00	QC21		DAS 21 9-89

Part Op 100 - 1-Cut as per Dwg D3077
Descriptions: 130 - Deburr to take measurement
170 - LOCATION : WA003

JUN 25 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	5.8330 sf (.5833 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.080	6	183	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Leg	11.958Inches ± 0.010	11.968 11.948	11,960	
2	Step Leg	11.250Inches ± 0.010	11.260 11.240	11,252	
3	Step Leg	2.250Inches ± 0.010	2.260 2.240	2,249	Pitch
4	Step Leg	0.213Inches + 0.005 - 0.000	0.218 0.213	0,215	Diameter

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only



Work Order: _____		AGAINST DEPARTMENT/PROCESS		Water Jet		Engineering	
Part No. _____		Rework		Prod. Eng. Coord.		Quality	
NCR No. _____		Scrap		Rec/Store/Packaging		Other	
Date: _____		Use-as-is		Supplier			
Step #: _____		Suspected Unapproved		Cross tube			
Description Work Order		Machining		Small Fab			
		Thermoforming		Finishing			
		Large Fab		Composite			
QTY Effective: _____							
MRB (QS042) Approval							
Completed By							
Lead hand / Supervisor							
Approval Verification							
QC / QA Coordinator							
Approval							
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com							
Container No: S081376							
Part: D3077 - 1							
Job No: 178498							
Serial No/Batch: S081376							
Revision:							
Inspector:							
Exp Date:							
Instructions:							
Date: 06/14/18							
Root Cause							
Environment							
Design							
Doc/Data							
Equip/Tooling							
Handling/Pre							
Material							
Internal Transport							
Tribal Knowledge							
LOA							
Substation							
Past Expiry Date							
Misidentified							
No Re-verification							
Operator							
Offset/Setup							
Supplier							
Training							
Use for Testing							
Poor Information							
Rushing							
Product Improvement							
Process Improvement							
Manufacturing Process							
Past Due							
OTHER: _____							
Positioned Wrong							
Outside Dimensions							
Over/Under tolerance							
Part Incorrect							
Part Lost/Missing							
Part Moved							
Drawing							
Finish							
Misread							
Turning Sequence							
Wrong Stock Pulled							
Out of Sequence							
Off-set							
Mislabeled							
Fit/Function							
Misaligned/off center							
Contamination							
Countersink							
Cut Too Short							
Instructions Incomplete/Unclear							
Drill Holes							

5	Step Leg	0.551Inches ± 0.010	0.561 0.541	0,550
6	Step Leg	5.016Inches ± 0.010	5.026 5.006	5,015
7	Step Leg	0.128Inches $+ 0.005$ $- 0.000$	0.133 0.128	0,129 Diameter
8	Step Leg	0.354Inches ± 0.010	0.364 0.344	0,354

Plex 6/1/18 7:30 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					